

Date: Thursday, 1/17/2008 3:32:10 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WINDOW
Job Number	: 36858		
Estimate Number	: 10063		
P.O. Number	:	Part Number	: D2958
This Issue	: 1/17/2008 S.O. No. :	Drawing Number	: D2958 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : THERMOFORMING	Drawing Revision	: E
Previous Run	: 33064	Material	:
Written By	:	Due Date	: 1/31/2008 Qty: 12 Um: Each
Checked & Approved By	:		
Comment	: E 01.09.25 Done by outside contract SM Est 07.06.26 Thermoform in house DL est 07.09.28 rev E dwg EC verified by:DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MACRLICS125	1/8" Polycast II Sheet
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29.8



Comment: Qty.: 2.7090 sf(s)/Unit Total : 32.5080 sf(s)  
 1/8" Polycast II Sheet

106174 x 8 = 21.672  
 104596 x 2 = 5.418  
 106049 x 1 = 27.090

PTO

Batch # 106174 IB 8-1-21

2.0	WATER JET	REV E	FLOW WATER JET
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REV E  
 REV E IB 8-1-21



11

Comment: FLOW WATER JET

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-1-21



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/01/22 (X 10)

5.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: THERMOFORMING MACHINE

Thermoform as per Dwg D2958 and Folio FTA005

Dwg. Rev. E  
 Folio Rev. B

08/01/22 (X 10)  
 BB

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2958 PAR #: PLA Fault Category: Red Thermal forming NCR: Yes No DQA: LD Date: 08/03/06  
 QA: N/C Closed: LD Date: 08/03/06

NCR: <u>36858</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/09/21</u>	<u>20</u>	<u>Three</u> <u>two windows SCRAP.</u> <u>1- with a large cut from the</u> <u>wake set.</u> <u>2- end of the sheet. missing</u> <u>about 1/4" of mat. also two</u> <u>large cuts from the wake</u> <u>set.</u> <u>3- large mark from</u> <u>the leading edge w/s</u>	<u>/</u> <u>@s1012</u>	<u>SCRAP and destroy</u> <u>only can replace one.</u> <u>Qty (43) B706049 x1</u>	<u>LD</u> <u>8-1-21</u>	<u>LD</u> <u>08/01/01</u>	<u>/</u> <u>@s1012</u>	<u>LD</u> <u>08/09/21</u>

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:32:10 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW

Job Number: 36858

Part Number: D2958

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check product for scratches mal-formation or any other non conformance.

FB 08/01/23.

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

08/01/23 (10)

8.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

Water sand and buff to remove scratches as required

08/01/23 (10)  
FB

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/23 (10)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

08/03/23 (10)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/23 (10)

Job Completion



mi 08/02/19  
(10)  
W

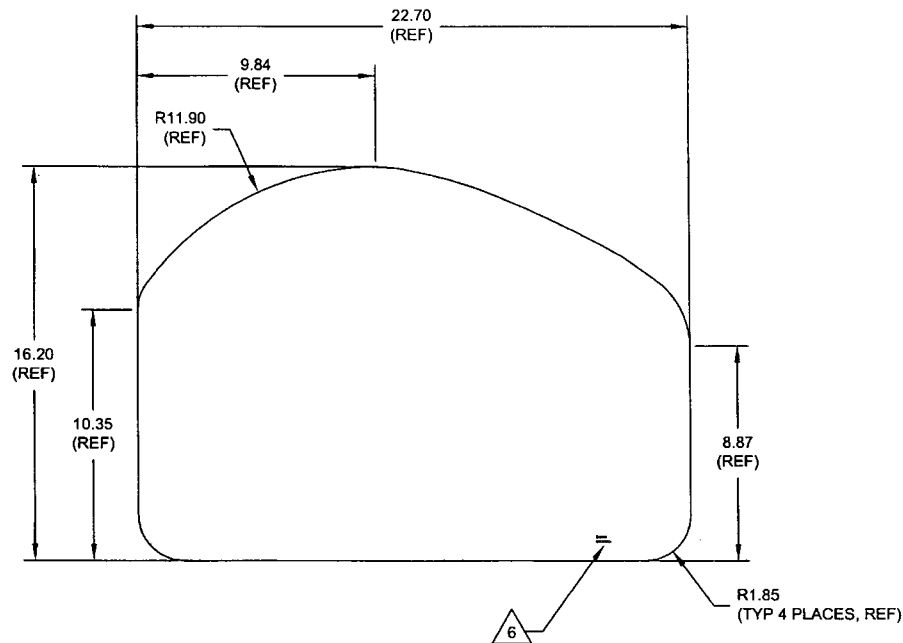
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D2958 FLAT PATTERN**

**RELEASED**  
07.09.22

**D2958 WINDOW:**

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D2958" AND B/N ON LOWER EDGE USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.58 +/- 0.35 LBS
- 8) MOLD PER DART TOOL DT8567

NO. 30858  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

E	UPDATE DIMS PER PAR 188	DC	07.07.06
D	UPDATE MATERIAL PER NCR 029	SSH	06.04.13
C	REMOVE HOLES, UNIFORMLY SMALLER	CP	01.05.30
B	Ø0.156 HOLES WERE Ø0.141 (NCR 407)	CP	00.02.23
A	NEW ISSUE	CP	00.01.20
REV.	DESCRIPTION	BY	DATE
DESIGN	JP		
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	07.07.06		

DART AEROSPACE LTD		HAWKESBURY, ONTARIO, CANADA	
DRAWING NO.	D2958	REV. E	SHEET 1 OF 1
TITLE	WINDOW	SCALE	1:5
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